

C1
operation, cracks are formed on the scales such that the subsequent descaling of the slabs is improved. --

In the claims:

Please cancel claims 4, 8, 16, 20.

Please amend claims 1, 6, 13, 16, 18, 20 as follows:

- 1. A method for manufacturing hot rolled steel sheets comprising the steps of:
- passing molten steel through a continuous caster having a mold after having been poured into a ladle and a tundish to manufacture a slab;
 - cutting the slab to predetermined lengths using a cutter to form a plurality of cut slabs;
 - heating the cut slabs to a predetermined temperature in a first heating furnace;
 - width rolling the cut slabs by using a width roller;
 - descaling the cut slabs in a reduction unit to a predetermined thickness to form a plurality of flat bars;
 - rolling the slabs in a reduction unit to a predetermined thickness in a second heating furnace;
 - coiling the flat bars by a coiling station while the flat bars are maintained in a heated state;
 - uncoiling the flat bars by an uncoiler; and
 - rolling the flat bars to a predetermined thickness in a finishing mill in a reversible manner.

- C2
- C3
6. The method of claim 1 wherein the slabs being rolled in the reduction unit are maintained to a temperature between 800 and 1000° C at an output of the reduction unit.

- C4
13. A method for manufacturing hot rolled steel sheets comprising the steps of:
- passing molten steel through a continuous caster having a first cutter to form a plurality of cut slabs;

heating the cut slabs to a first predetermined temperature in a first heating furnace;

width rolling the cut slabs by using a width roller;

descaling the cut slabs heated in the first heating furnace;

rolling the slabs in a reduction unit to a predetermined thickness to form a plurality of flat bars;

heating the flat bars to a second predetermined temperate [of a second rolling] in a second heating furnace;

coiling the flat bars by a coiling station while the flat bars are maintained in a heated state;

uncoiling the plurality of flat bars by uncoilers; and

rolling the flat bars to a predetermined thickness in a finishing mill, in a reversible manner, while a rear end of a flat bar undergoing rolling is joined to a front end of

another flat bar waiting to be rolled such that the flat bars can be continuously rolled; and

cutting the flat bars to a predetermined length by a third cutter.

18. The method of claim 13 wherein the slabs being rolled in the reduction unit are maintained to a temperature between 800 and 1000° C at an output of the reduction unit.

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